

Monday, 5/7/2007 9:12:56 AM  
Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER  
 Job Number : 31865  
 Estimate Number : 12825  
 P.O. Number : N/A Part Number : D3578041  
 This Issue : 5/7/2007 S.O. No. : N/A Drawing Number : D3578 REVA  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 4/17/2007 Type : SMALL / MED FAB Drawing Revision : A  
 Previous Run : N/A Material : N/A Due Date : 5/12/2007 Qty: 60 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est: A 07.04.11 New issue EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.0074 sf(s)/Unit Total : 0.4410 sf(s)  
 6061-T6 sheet 0.080"  
 (M6061T6S080)  
 Batch: *See Attached.*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3578 (Run prog. D3578-1)  
 Dwg Rev: \_\_\_\_\_  
 Prog Rev: \_\_\_\_\_  
 2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Open rivet holes to 0.098" and C'sink as per dwg D3578

X60

*m 07/05/07*

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 31865

Part Number: D3578041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



BOX

Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

M-d 07/05/10

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/05/16

8.0 MS21075L3 Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)  
Nutplate  
Batch: M18534

SB 07/05/16 60

9.0 MS20426AD33 Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s)  
Rivet M1563

SB 07/05/16 60

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

2-Assemble as per dwg D3578

FF 07-05-16 60

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/16 60

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

u 07-05-16 60

Date: Monday, 5/7/2007 9:12:57 AM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 31865

Part Number: D3578041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(60)

Comment: FINAL INSPECTION/W/O RELEASE

27/05/16

Job Completion



27/05/16

Date: Tuesday, 4/17/2007 11:13:38 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 31865	
Estimate Number : 12825	
P.O. Number :	Part Number : D3578041
This Issue : 4/17/2007 S.O. No. :	Drawing Number : D3578 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run :	Material :
Written By : <u>[Signature]</u>	Due Date : 5/12/2007 Qty: 60 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: A 07.04.11 New issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0074 sf(s)/Unit Total : 0.4410 sf(s)  
 6061-T6 sheet 0.080"  
 (M6061T6S080)  
 Batch: M104186

SAD 07/04/05 (60)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3578 (Run prog. D3578-1)  
 Dwg Rev: A  
 Prog Rev: A

SAD 07/05/04

(60)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/04

(60)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S.L 07/05/04

5.0	MS21075L3	Nutplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)  
 Nutplate  
 Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del>07/05/16</del>	10	<del>split into</del>		<del>07/05/16</del>			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<del>07/05/16</del>	10	<del>SP</del>		<del>split into</del>				

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:13:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 31865

Part Number: D3578041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 120.0000 Each(s)  
Rivet

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

2-Assemble as per dwg D3578

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

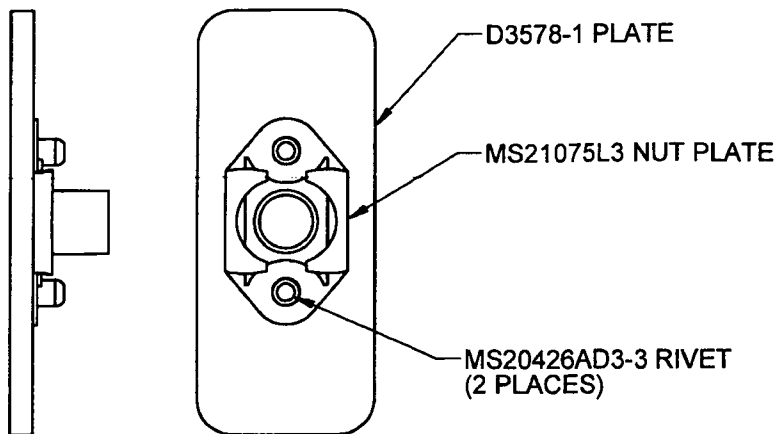
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3578</b>	REV. A SHEET 1 OF 1
DATE <b>07.01.12</b>		TITLE <b>DOUBLER</b>	SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



**RELEASED**  
07.04.02

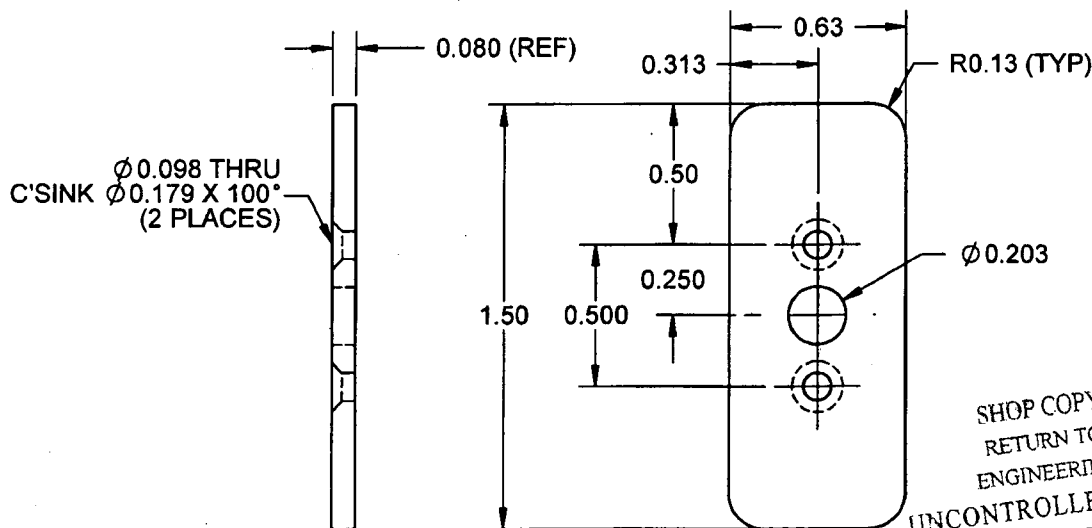
**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

**D3578-041 DOUBLER**

**D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



**D3578-1 PLATE**

**D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **31865**



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